

End of July

Work Order ID 71412

Monday, July 04, 2011 10:44:52 AM



Page 1

Item ID: D4131-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Manifold Assembly

Start Date: 7/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MC

Date: 11-07-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4131

A

100

Weld per dwg A/R S.S. rod Batch: M114509 0.00



Large Fab

Memo

0.00

Large Fab

A 11-8-30 (X10)

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

Pl 11-08-30

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

8 uloe/30

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71412

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 132

0.00



Packaging

Memo

0.00

Packaging

11/8/30

5/10

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/30

me 11-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, July 04, 2011 10:44:50 AM

Page 1

Work Order ID: 71412

Parent Item: D4131-041

Parent Item Name: Manifold Assembly



Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4131-1 Front Plate		Manufactured	No			100	Each	4.0000	1	4			
		72468x8 71414x2		<u>Location</u> ST131				<u>Loc Qty</u> 4					
					70318			4					
D4131-3 Base		Manufactured	No			100	Each	2.0000	1	4			
		72469x10		<u>Location</u> ST131				<u>Loc Qty</u> 2					
					70319			2					
D4131-5 Side Plate		Manufactured	No			100	Each	10.0000	2	8			
				<u>Location</u> WA				<u>Loc Qty</u> 10					
					70321			10					
		71415x5 72470x15											



EL 11-8-25



EL 11-8-25



EL 11-8-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

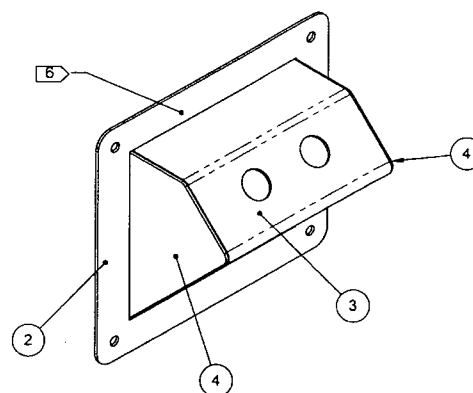
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4131-041	MANIFOLD ASSEMBLY
2	1	D4131-1	FRONT PLATE
3	1	D4131-3	BASE
4	2	D4131-5	SIDE PLATE



D4131-041 MANIFOLD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.64 lbs

RELEASED
2010-09-23

A		NEW ISSUE		RF	10.09.16
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.			
DRAWN	RF	PORT HADLOCK, WA			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A		
MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 1 OF 8		
APPROVED	<i>[Signature]</i>	TITLE	SCALE		
DE APPR.	<i>[Signature]</i>	MANIFOLD ASSEMBLY	NTS		
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

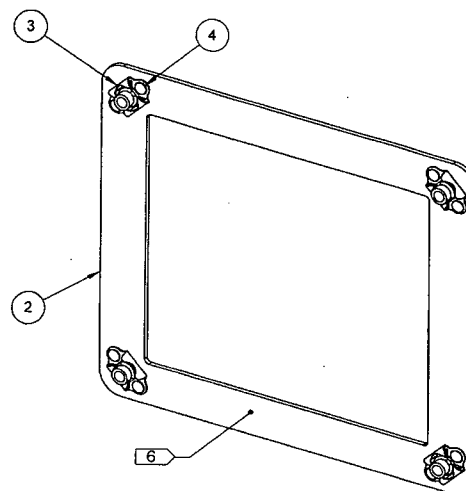
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4131-043	DOUBLER ASSEMBLY
2	1	D4131-7	DOUBLER
3	4	MS21069L3	NUT PLATE
4	8	MS20426AD3-3	RIVET



D4131-043 DOUBLER ASSEMBLY

#71412

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2010-09-23
WNP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

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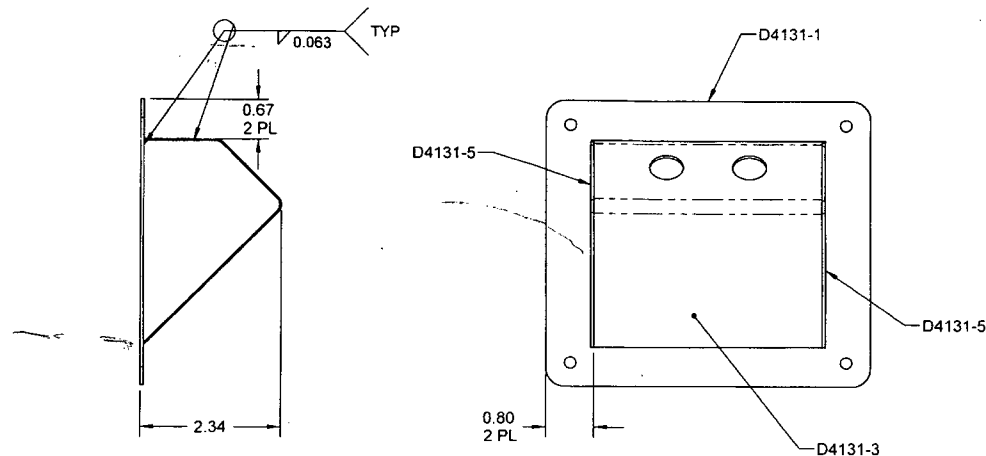
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4131-041 MANIFOLD ASSEMBLY

#71412

RELEASED
2010-09-23
ND

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004

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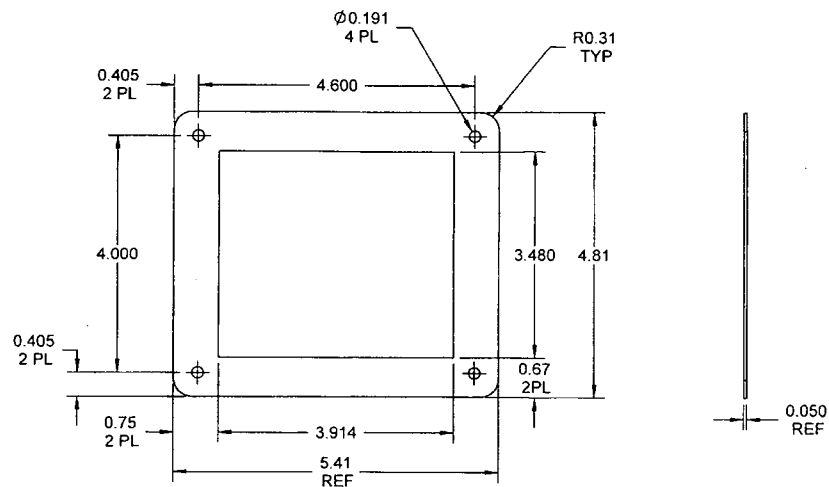
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4131-1 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

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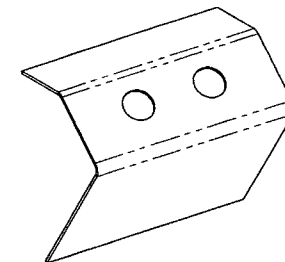
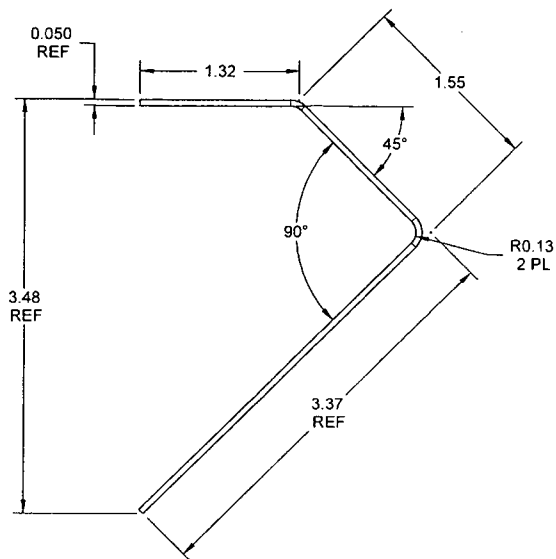
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4131-3 BASE
MAKE FROM D4131-3F FLAT PATTERN

RELEASED
2010-09-23

NOTES:

- 1) MATERIAL: MAKE FROM D4131-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

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MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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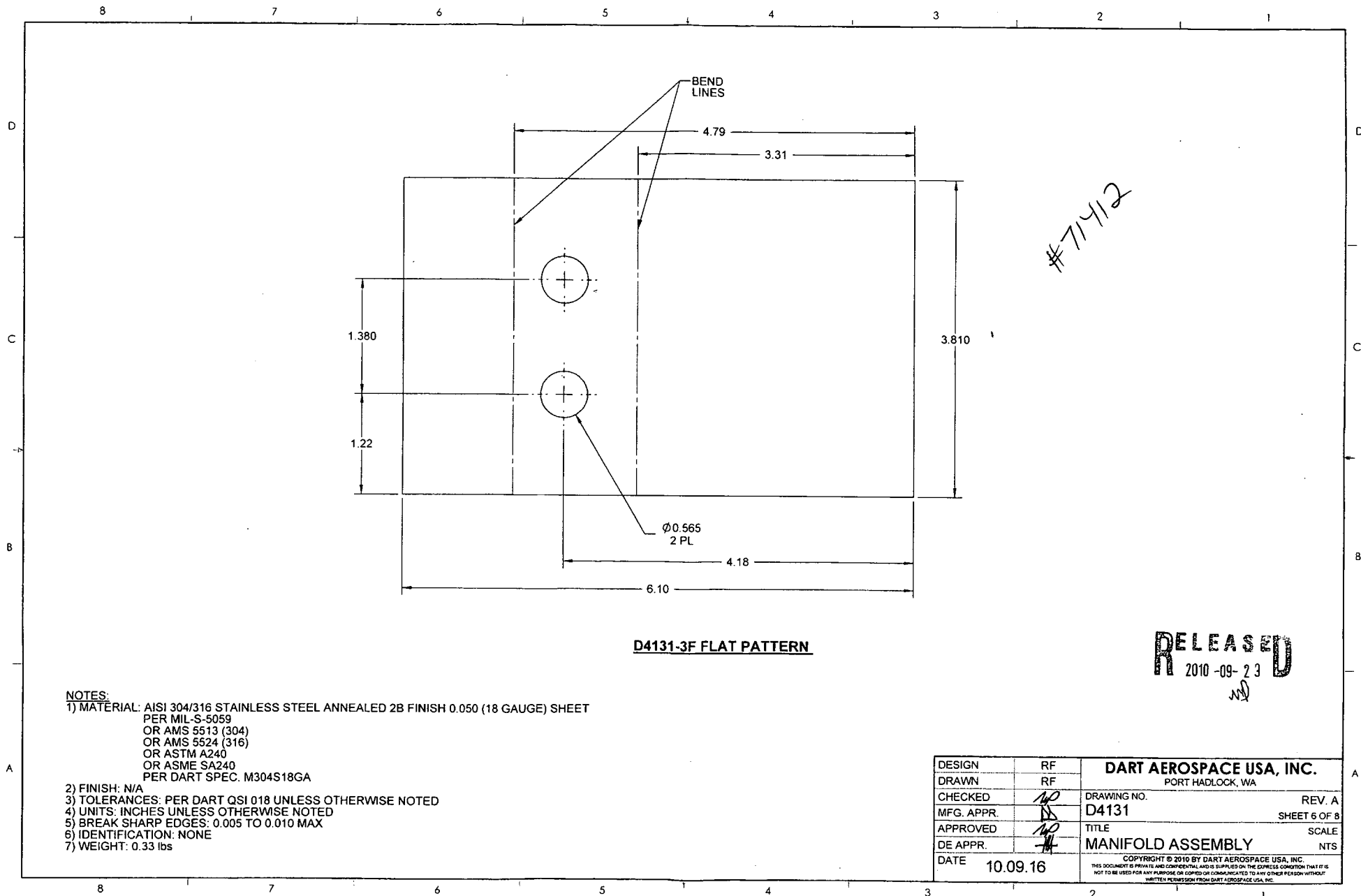
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4131-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

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2010-09-23
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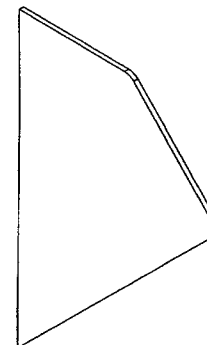
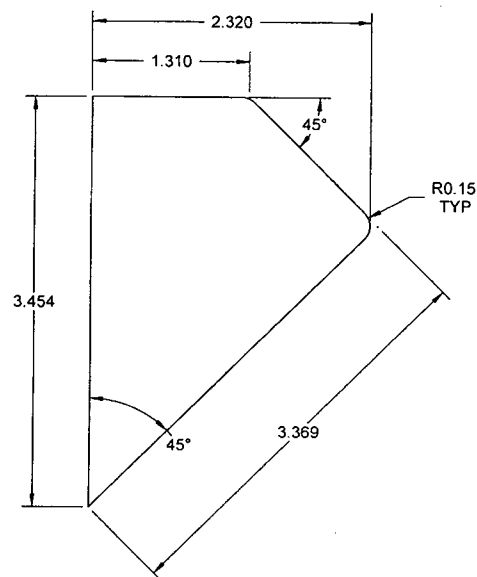
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#71412

D4131-5 SIDE PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

RELEASED
2010-09-23
JW

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4131	SHEET 7 OF 8
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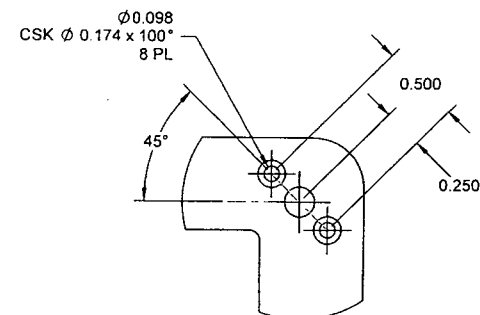
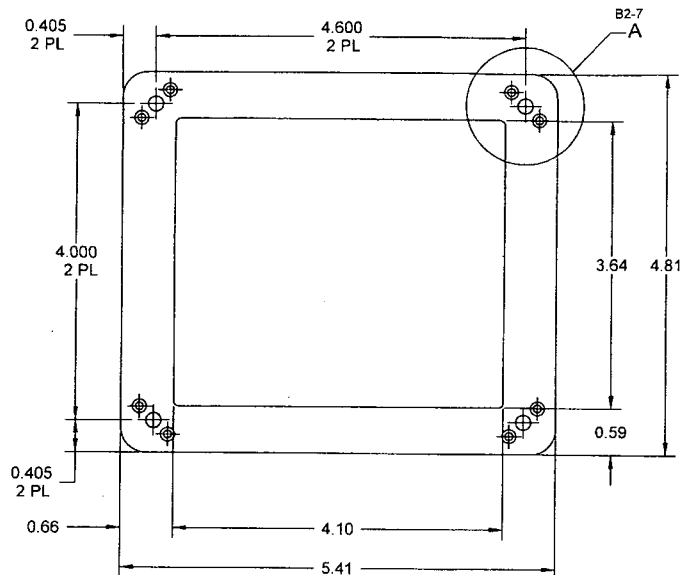
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NOTE: Date & initial all entries



DETAIL A D5-7
TYPICAL

D4131-7 PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS4027
OR ASTM B209
PER DART SPEC. M6061T6S0.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

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2010-09-23

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